

Date: Tuesday, 11/03/2008 8:25:45 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: ANGLE		
Job Number	: 37762			Part Number	: D37411		
Estimate Number	: 13168			Drawing Number	: D3741 UNDER REVIEW		
P.O. Number	:			Project Number	: N/A		
This Issue	: 11/03/2008	S.O. No.	:	Drawing Revision	<i>X B3G 11/03/08-12</i>		
Prsht Rev.	: NC			Material			
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 14/03/2008 Qty: 24 Um: Each		
Previous Run	: 37400						
Written By	:						
Checked & Approved By	:						
Comment	: Est Rev:A 08-01-30 new issue DD verified by:						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6207 D6203	Angle Extrusion 1x4x125 1.5x1.5x.125
<b>Comment:</b> Qty.: 0.0656 f(s)/Unit Total : 1.5750 f(s) D6207 angle extrusion Batch: <i>B31395</i> <i>SG 08-03-12</i>		
2.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
<b>Comment:</b> 1-drill holes as per dwg D3741 <i>2-Deburr</i> <i>SG 08-03-12 24</i>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <i>SG 08-03-12 24</i>		
4.0	QC8	SECOND CHECK
<b>Comment:</b> SECOND CHECK <i>SG 08/03/12 24</i>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 1- Grind radius as per dwg D3741 2- Deburr if necessary <i>Ap08/03/13 (24)</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: 10 Date: 08/03/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/03/2008 8:25:45 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 37762

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/13 (24)

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*M. M.* 08/03/13

24X

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M. L.* 08/03/13

24X

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA*

*M. L.* 08.03.13 24

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*M. L.* 08/03/13

24

Job Completion



*M. L.* 2008/3/13

(24)

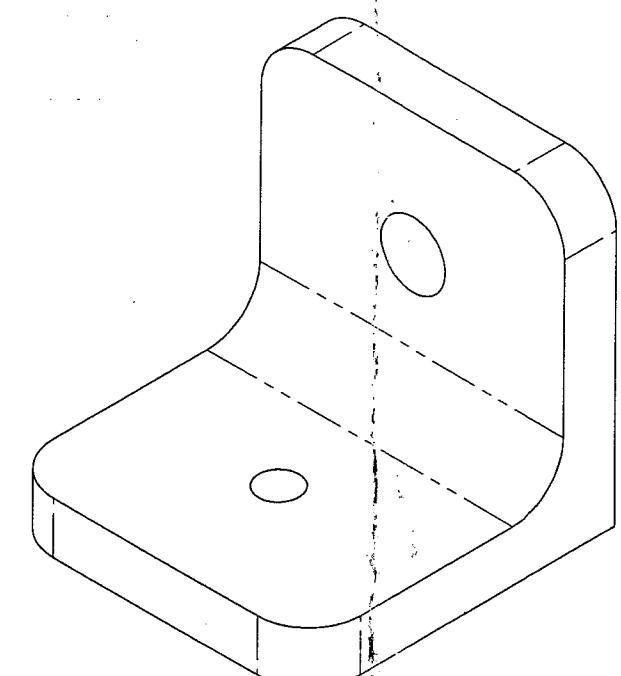
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8	7	6	5	4	3	2	1
D							D
C							C
B							B
A							A



**D3741-1 ANGLE** △

**PRELIMINARY ISSUE**  
AJS 08.03.12

**NOTES:**

- 1) MATERIAL: 6061-T6/T6510/T6511 ALU MINUM ANGLE, 0.75 X 0.75 X 0.125 PER AMS-QQ-A-200/8 (REF. DART SPEC. M6061T6A750XW125) △
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

B	SHEET 1 NOTES DART SPEC IN MATERIALS UPDATED, ISO VIEW UPDATED. SHEET 2 ZONE D5, $\phi 0.098$ HOLE WAS $\phi 0.159$ .			AJS	08.03.06
A	NEW ISSUE			AJS	08.02.04
REV.	DESCRIPTION			BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWN	AJS				REV. B
CHECKED	LG	DRAWING NO.			
MFG. APPR.	M	D3741			SHEET 1 OF 2
APPROVED	M	TITLE			SCALE
DE APPR.	M	ANGLE			NTS
DATE	08.03.06			COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

D

D

C

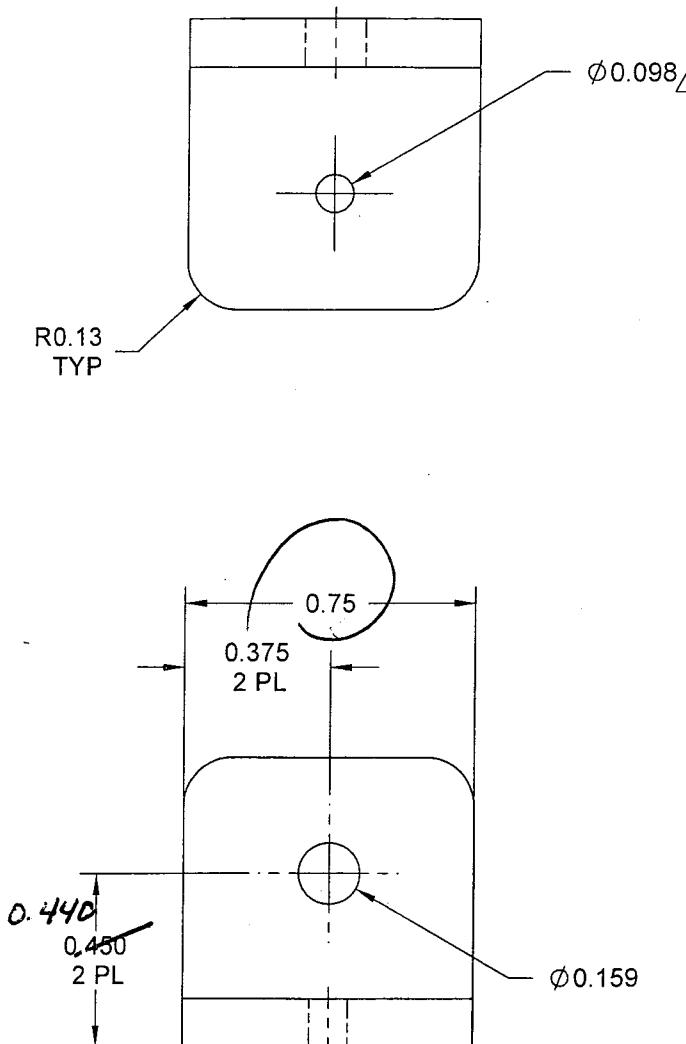
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B

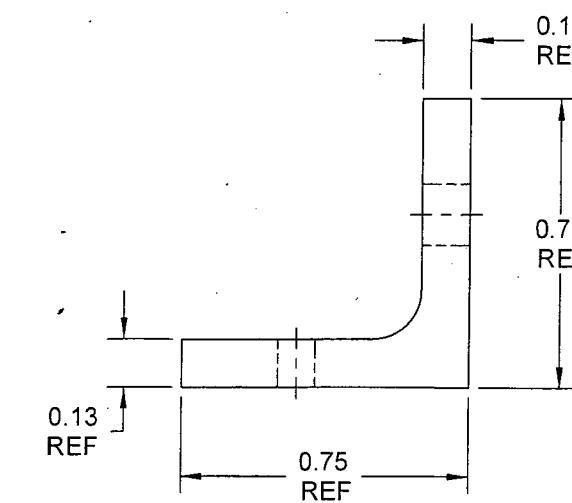
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D3741-1 ANGLE



**PRELIMINARY ISSUE**

AJS 08.03.06

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	
MFG. APPR.	NP	REV. B	
APPROVED	MM	D3741	
DE APPR.	MM	SHEET 2 OF 2	
DATE	08.03.06	TITLE	ANGLE
		SCALE	NTS
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DART AEROSPACE LTD	Work Order:	31762
Description: Angle	Part Number:	D 3741-1
Inspection Dwg: D 3741 Rev: A		Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## First Article      Prototype

Measured by:	SGJ	Audited by:	SA /06/05/12	Prototype Approval:	
Date:		Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	